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(54) **METHOD FOR MANUFACTURING HIGH STRENGTH GALVANIZED STEEL SHEET HAVING EXCELLENT STABILITY OF MECHANICAL PROPERTIES, FORMABILITY, AND COATING APPEARANCE**

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See application file for complete search history.

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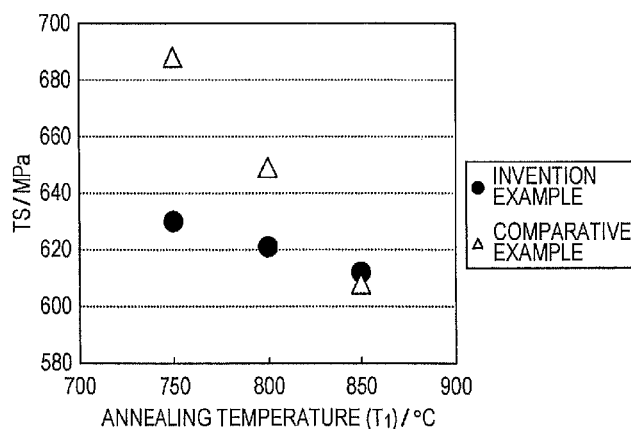
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(57) **ABSTRACT**

A method of manufacturing a high strength galvanized steel sheet has a first heating step including heating to 400° C. to 750° C. in an atmosphere containing O₂: 0.1 to 20 percent and H₂O: 1 to 50 percent and heating to 600° C. to 850° C. in an atmosphere containing O₂: 0.01 to less than 0.1 percent and H₂O: 1 to 20 percent is applied to a steel sheet, a second heating step includes holding the steel sheet in an atmosphere containing H₂: 1 to 50 percent and having a dew point of 0° C. or lower at 750° C. to 900° C. for 15 to 600 s, cooling to a temperature of 450° C. to 550° C., and holding is performed at that temperature for 10 to 200 s, and a galvanization treatment is applied.

12 Claims, 2 Drawing Sheets



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C22C 38/06 (2006.01)
C22C 38/58 (2006.01) (56) **References Cited**
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C22C 38/04 (2006.01)
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FIG. 1

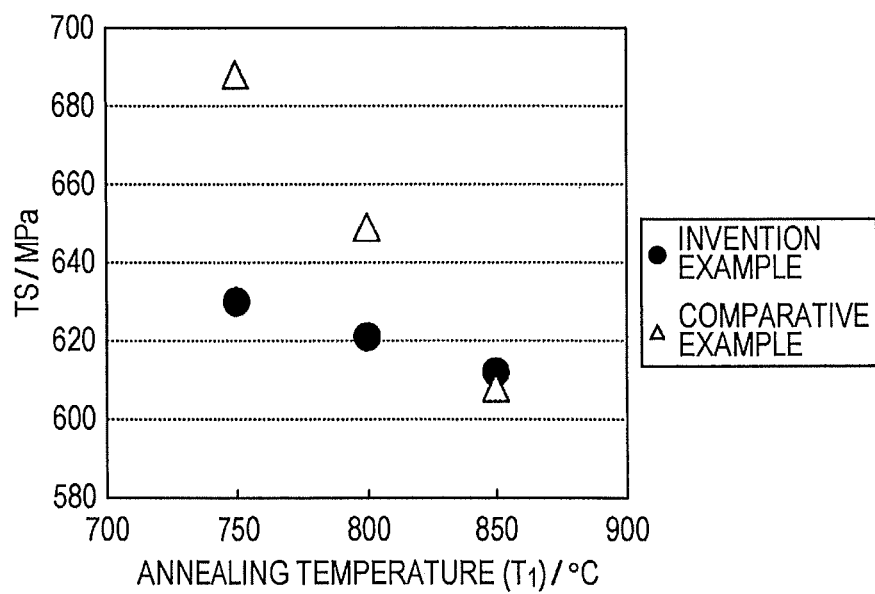


FIG. 2

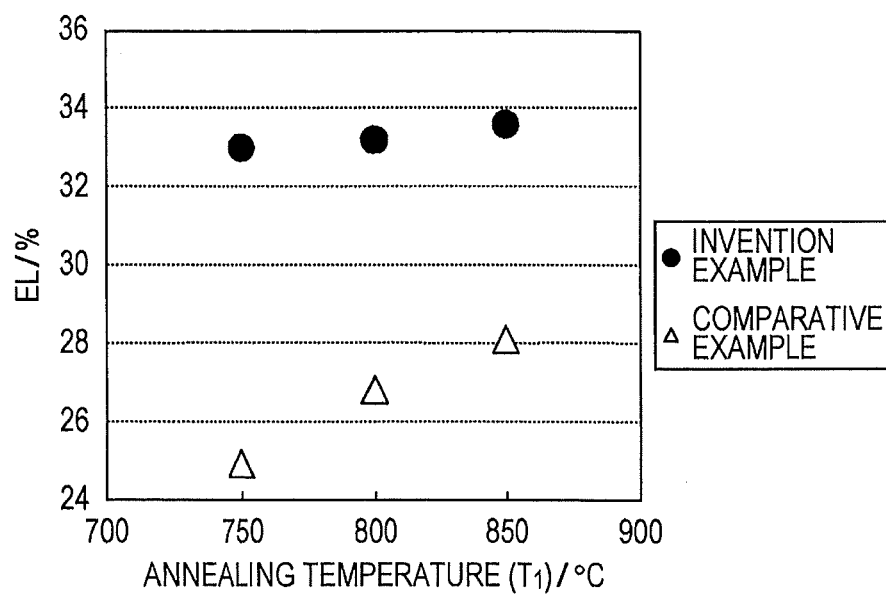


FIG. 3

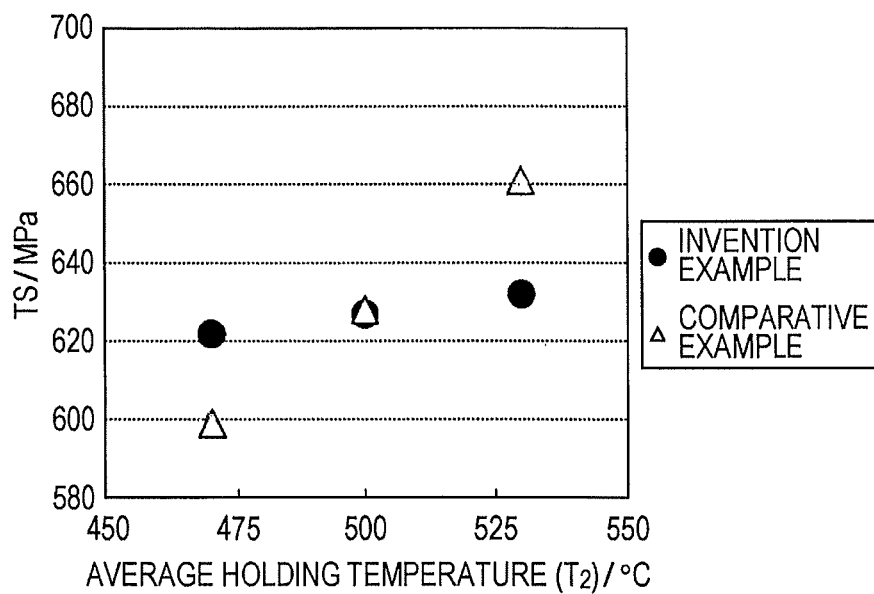
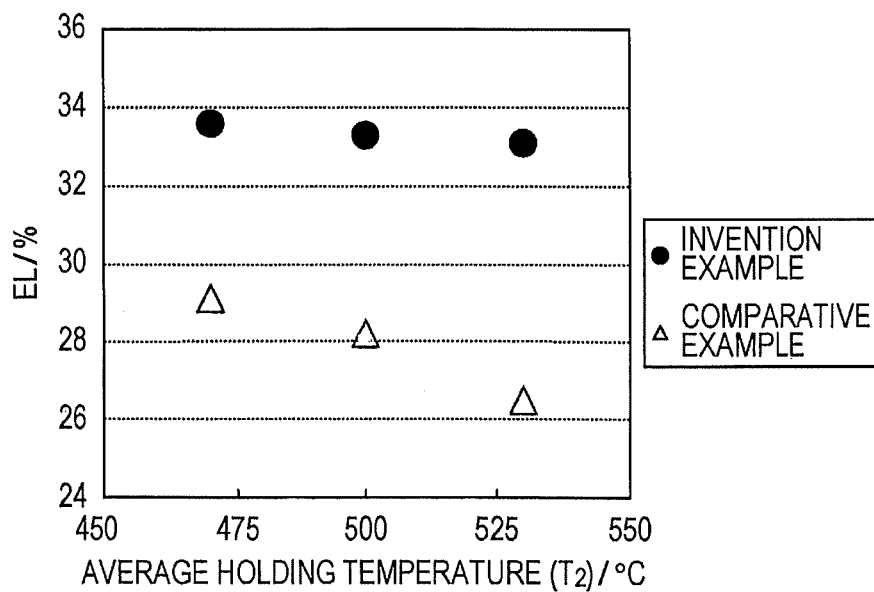


FIG. 4



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**METHOD FOR MANUFACTURING HIGH
STRENGTH GALVANIZED STEEL SHEET
HAVING EXCELLENT STABILITY OF
MECHANICAL PROPERTIES,
FORMABILITY, AND COATING
APPEARANCE**

TECHNICAL FIELD

This disclosure relates to a method of manufacturing a high strength galvanized steel sheet suitable for a member used in the industrial fields of automobiles, electric appliances and the like and which has excellent stability of mechanical properties, formability, and, in addition, coating appearance.

BACKGROUND

In recent years, enhancement of fuel economy of the automobile has become an important issue from the viewpoint of global environmental conservation. Consequently, there is an active movement afoot to reduce the thickness through increases in strength of car body materials to reduce the weight of a car body itself.

However, an increase in strength of a steel sheet causes reduction in ductility, that is, reduction in formability. Therefore, development of materials having high strength and high formability in combination has been desired.

Furthermore, in forming of the high strength steel sheet into a complicated shape, e.g., an automobile component, occurrences of cracking and necking in a punch stretch portion or a stretch flange portion cause serious issues. Therefore, a high strength steel sheet which can overcome the issues on occurrences of cracking and necking and which has high ductility and high hole expansion property in combination has also been required.

Moreover, shape fixability is degraded by an increase in strength and thickness reduction of a steel sheet significantly. To cope with this, in press forming, it has been widely performed that changes in shape after release from a mold is predicted and the mold is designed in expectation of the amount of change in shape. However, if the tensile strength (TS) of a steel sheet is changed, deviation from the expected amount, in which the tensile strength is assumed to be constant, becomes large and odd shapes occur. Consequently, reworking, e.g., sheet-metal working of the shape on a one-by-one basis, becomes necessary after press-forming, and efficiency in mass production is degraded significantly. Therefore, it is required that variations in TS of the steel sheet are minimized.

As for an improvement of formability of the high strength steel sheet, heretofore, various multi phase high strength galvanized steel sheets, e.g., a ferrite-martensite dual-phase steel and a TRIP steel taking advantage of the transformation induced plasticity of retained austenite, have been developed.

For example, Japanese Unexamined Patent Application Publication No. 2001-140022 discloses a method of manufacturing a galvanized steel sheet having excellent ductility by specifying the chemical composition to be within a specific range and, in addition, specifying the volume ratios of retained austenite and martensite and the manufacturing conditions. Meanwhile, Japanese Unexamined Patent Application Publication No. 04-026744 discloses a galvanized steel sheet having excellent ductility by specifying the chemical composition to be within a specific range and, in addition, specifying the specific manufacturing condition. Japanese Unexamined Patent Application Publication No. 2007-182625 discloses a galvanized steel sheet having excellent

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ductility by specifying the chemical composition to be within a specific range and, in addition, specifying the volume ratios of ferrite, bainitic ferrite, and retained austenite within specific ranges. Meanwhile, Japanese Unexamined Patent Application Publication No. 2000-212684 discloses a method of manufacturing a high strength cold rolled steel sheet which contains ferrite, bainite, and 3% or more of retained austenite and in which variations in elongation in the sheet width direction have been reduced.

However, in JP '022, JP '744 and JP '625, an improvement in ductility of the high strength thin steel sheet is the main purpose. Therefore, the hole expansion property is not taken into consideration. Also, in JP '684, only variations in the total elongation EL in the sheet width direction are described, and variations in mechanical properties due to the component composition and the production condition are not taken into consideration. As described above, in every technology, a high strength galvanized steel sheet having high ductility and high hole expansion property in combination and, in addition, having excellent stability of mechanical properties has not been obtained.

It could therefore be helpful to provide a method of manufacturing a high strength galvanized steel sheet having a tensile strength TS of 540 MPa or more and having excellent stability of mechanical properties and formability (high ductility and high hole expansion property) and, in addition, excellent coating appearance.

SUMMARY

We thus provide:

- (1) A method for manufacturing a high strength galvanized steel sheet having excellent stability of mechanical properties, formability, and coating appearance, characterized by including the steps of applying a first heating step to the steel sheet containing C: 0.04% or more and 0.13% or less, Si: 0.7% or more and 2.3% or less, Mn: 0.8% or more and 2.0% or less, P: 0.1% or less, S: 0.01% or less, Al: 0.1% or less, N: 0.008% or less, and the remainder composed of Fe and incidental impurities, on a percent by mass basis, in which, in the former part, heating is performed in an atmosphere containing O₂: 0.1 to 20 percent by volume and H₂O: 1 to 50 percent by volume such that the temperature thereof becomes within the range of 400° C. to 750° C. and, in the latter part, heating of the steel sheet is performed in an atmosphere containing O₂: 0.01 to less than 0.1 percent by volume and H₂O: 1 to 20 percent by volume such that the temperature of the steel sheet becomes within the range of 600° C. to 850° C., applying a second heating step to the resultant steel sheet, in which holding of the steel sheet is performed in an atmosphere containing H₂: 1 to 50 percent by volume and having a dew point of 0° C. or lower in a temperature range of 750° C. to 900° C. for 15 to 600 s, cooling to a temperature range of 450° C. to 550° C. is performed, and holding is performed in the temperature range of 450° C. to 550° C. for 10 to 200 s, and applying a galvanization treatment, wherein an obtained galvanized steel sheet includes 75% or more of ferrite phase, 1.0% or more of bainitic ferrite phase, and 1.0% or more and 10.0% or less of pearlite phase, on an area ratio basis, the area ratio of martensite phase is 1.0% or more and less than 5.0%, and the area ratio of martensite phase/(area ratio of bainitic ferrite phase+area ratio of pearlite phase) 0.6 is satisfied.
- (2) The method for manufacturing a high strength galvanized steel sheet having excellent stability of mechanical

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cal properties, formability, and coating appearance, according to the above-described item (1), characterized in that the above-described steel sheet further contains at least one type of element selected from Cr: 1.0% or less, V: 0.5% or less, Mo: 0.5% or less, Ni: 1.0% or less, and Cu: 1.0% or less on a percent by mass basis.

(3) The method for manufacturing a high strength galvanized steel sheet having excellent stability of mechanical properties, formability, and coating appearance, according to the above-described item (1) or item (2), characterized in that the above-described steel sheet further contains at least one type of element selected from Ti: 0.1% or less, Nb: 0.1% or less, and B: 0.0050% or less on a percent by mass basis.

(4) The method for manufacturing a high strength galvanized steel sheet having excellent stability of mechanical properties, formability, and coating appearance, according to any one of the above-described items (1) to (3), characterized in that the above-described steel sheet further contains at least one type of element selected from Ca: 0.005% or less and REM: 0.005% or less on a percent by mass basis.

(5) The method for manufacturing a high strength galvanized steel sheet having excellent stability of mechanical properties, formability, and coating appearance, according to any one of the above-described items (1) to (4), characterized in that the former part of the above-described first heating step is performed with a direct fired furnace or a non-oxidizing furnace under the condition of the air ratio of 1 or more and 1.3 or less and the latter part of the above-described first heating step is performed with a direct fired furnace or a non-oxidizing furnace under the condition of the air ratio of 0.6 or more and less than 1.

(6) The method for manufacturing a high strength galvanized steel sheet having excellent stability of mechanical properties, formability, and coating appearance, according to any one of the above-described items (1) to (5), characterized in that, after the above-described galvanization treatment is applied, an alloying treatment of zinc coating is performed at a temperature of 500° C. to 600° C. under the condition satisfying the following formula:

$$0.45 \leq \exp[200/(400-T)] \times \ln(t) \leq 1.0$$

where

T: average holding temperature (° C.) at a temperature of 500° C. to 600° C.,

t: holding time (s) at a temperature of 500° C. to 600° C., and

$\exp(X)$ and $\ln(X)$ represent an exponential function and natural logarithm, respectively, of X.

In this regard, every % indicating a component of a steel is on a percent by mass basis. Furthermore, "high strength galvanized steel sheet" refers to a galvanized steel sheet having a tensile strength TS of 540 MPa or more.

Moreover, regardless of whether an alloying treatment is performed or not, steel sheets in which a zinc coating is applied to a steel sheet by galvanization are generically called galvanized steel sheets. That is, the galvanized steel sheets include both galvanized steel sheets not subjected to an alloying treatment and galvanized steel sheets subjected to an alloying treatment.

A high strength galvanized steel sheet, which has a tensile strength TS of 540 MPa or more, which has excellent formability and stability of mechanical properties because of high ductility and high hole expansion property and, furthermore,

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which has excellent coating appearance, is obtained. In the case where the high strength galvanized steel sheet is applied to, for example, an automobile structural member, enhancement of fuel economy due to weight reduction of a car body can be facilitated. Therefore, an industrial utility value is very large.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a diagram showing the relationship between the annealing temperature (T_1) and TS.

FIG. 2 is a diagram showing the relationship between the annealing temperature (T_1) and EL.

FIG. 3 is a diagram showing the relationship between the cooling average holding temperature (T_2) and TS.

FIG. 4 is a diagram showing the relationship between the cooling average holding temperature (T_2) and EL.

DETAILED DESCRIPTION

We found the following:

By specifying the Si content to be more than or equal to a predetermined amount by virtue of intentional addition of Si, an improvement of ductility due to an improvement of a work hardening property of ferrite, ensuring of strength due to solution hardening of ferrite, and an improvement of hole expansion property due to relaxation of hardness difference from a secondary phase become possible.

By making the most of bainitic ferrite and pearlite, the hardness difference between mild ferrite and hard martensite can be relaxed and the hole expansion property can be improved.

If much hard martensite is present in a final microstructure, a large hardness difference occurs at an interface between the mild ferrite phase and a different phase, so that the hole expansion property is degraded. Therefore, untransformed austenite, which is transformed to martensite finally, is converted to pearlite and, thereby, a microstructure including ferrite, bainitic ferrite, pearlite, a small amount of martensite is formed, so that the hole expansion property can be improved while high ductility is maintained. In addition, the area ratio of each of the above-described phases is controlled appropriately and, thereby, the stability of mechanical properties can be ensured.

Meanwhile, it has been known that the coating appearance is degraded if Si is contained. Usually, as for a galvanized steel sheet, a heat treatment is performed in a reducing atmosphere and, thereafter, a galvanization treatment is performed. Si added to the steel is an easy-to-be-oxidized element and, therefore, is selectively oxidized even in the commonly used reducing atmosphere to form Si oxide on the surface of the steel sheet. The resulting oxide reduces the wettability with molten zinc during a coating treatment and cause bare spots. Therefore, the wettability is reduced along with an increase in the Si concentration in the steel and bare spots occurs frequently.

To cope with such problems, the wettability with the molten zinc can be improved by heating the steel sheet in advance in an oxidizing atmosphere to form iron oxide on the surface and, thereafter, performing reduction annealing. On the other hand, iron oxide peeled from the steel sheet surface at the initial stage of the reduction annealing may adhere to a roll and cause a scale mark on the steel sheet surface. As a result of our efforts to find a solution to such an issue linked to peeling of iron oxide from the steel sheet surface, we found

that the peeling of iron oxide was suppressed by heating the steel sheet in a slightly oxidizing atmosphere after iron oxide was formed to reduce the outermost surface of iron oxide.

Our methods and steel sheets will now be described below in detail.

(1) Initially, the component composition will be described.

(a) C: 0.04% or More and 0.13% or Less

Carbon is an austenite forming element and is an element indispensable for strengthening a steel. It is difficult to ensure predetermined strength if the C content is less than 0.04%. On the other hand, if the C content is more than 0.13%, a welded zone and a heat-affected zone are hardened significantly, and the mechanical characteristics of the welded zone are degraded, so that the spot weldability, the arc weldability, and the like are degraded. Therefore, the C content is 0.04% or more and 0.13% or less.

(b) Si: 0.7% or More and 2.3% or Less

Silicon is a ferrite forming element and is also an element effective in solution hardening. It is necessary that 0.7% or more of Si be contained to ensure good ductility due to an improvement in work hardening property of the ferrite phase. Furthermore, it is also necessary that 0.7% or more be contained to ensure a predetermined area ratio of bainitic ferrite phase and ensure good hole expansion property. However, if Si is excessively contained, degradation of surface quality due to an occurrence of red scale and the like and degradation of deposition and adhesion of the coating are caused. Therefore, the Si content is 0.7% or more and 2.3% or less, and preferably 1.2% or more and 1.8% or less.

(c) Mn: 0.8% or More and 2.0% or Less

Manganese is an element effective in strengthening a steel. Furthermore, Mn is an element to stabilize austenite and an element necessary to adjust the ratio of a secondary phase. For this purpose, it is necessary that 0.8% or more of Mn be contained. On the other hand, if the content is excessive and is more than 2.0%, the area ratio of martensite phase in the secondary phase increases and it becomes difficult to ensure the stability of mechanical properties. Moreover, an increase in cost is brought about because an alloy cost of Mn has increased in recent years. Therefore, the Mn content is 0.8% or more and 2.0% or less, and preferably 1.0% or more and 1.8% or less.

(d) P: 0.1% or Less

Phosphorus is an element effective in strengthening a steel. However, if the content is excessive and is more than 0.1%, embrittlement is caused by grain boundary segregation, and the impact resistance is degraded. Furthermore, if the content is more than 0.1%, an alloying rate is reduced significantly. Therefore, the P content is 0.1% or less.

(e) S: 0.01% or Less

Sulfur forms inclusions, e.g., MnS, to cause degradation in impact resistance and cracking along a metal flow of a welded zone. Therefore, the content thereof is minimized, although the S content is 0.01% or less from the viewpoint of production cost.

(f) Al: 0.1% or Less

Coarse Al_2O_3 is generated and the quality of steel sheets is degraded if the Al content is more than 0.1%. Therefore, the Al content is 0.1% or less. Meanwhile, in the case where Al is added for deoxidation of a steel, it is preferable that the content is 0.01% or more because, if the content thereof is less than 0.01%, a large number of coarse oxides of Mn, Si, and the like are dispersed in the steel to degrade the quality. Therefore, the preferable range of the Al content is 0.01% to 0.1%.

(g) N: 0.008% or Less

Nitrogen is an element which degrades the aging resistance of a steel to a greatest extent and preferably is minimized. Degradation of the aging resistance becomes significant if the content thereof is more than 0.008%. Therefore, the N content is 0.008% or less.

The remainder is composed of Fe and incidental impurities. However, besides these elements, at least one type selected from the following elements can be added, as necessary.

(h) at Least One Type Selected from Cr: 1.0% or Less, V: 0.5% or Less, Mo: 0.5% or Less, Ni: 1.0% or Less, and Cu: 1.0% or Less

Chromium, vanadium, and molybdenum have a function of improving the balance between strength and ductility and, therefore, can be added as necessary. However, if Cr, V, and Mo are added to exceed Cr: 1.0%, V: 0.5%, and Mo: 0.5%, respectively, the secondary phase ratio becomes too large, and concerns rise over a significant increase in strength and the like. Furthermore, an increase in cost is brought about. Therefore, in the case where these elements are added, the individual amounts thereof are Cr: 1.0% or less, V: 0.5% or less, and Mo: 0.5% or less. So that the above-described effects are effectively exerted, Cr: 0.05% or more, V: 0.005% or more, and Mo: 0.005% or more are preferable.

Nickel and copper are elements effective in strengthening a steel and can be added as necessary. Furthermore, there is a function of facilitating internal oxidation to improve adhesion of the coating. However, if both Ni and Cu, more than 1.0% each, are contained, formability of the steel sheet is degraded. Moreover, an increase in cost is brought about. Therefore, in the case where Ni and Cu are added, the content of each of them is 1.0% or less. In this regard, so that the above-described effects are effectively exerted, each of the contents of Ni and Cu is preferably 0.05% or more.

(i) at Least One Type Selected from Ti: 0.1% or Less, Nb: 0.1% or Less, and B: 0.0050% or Less

Titanium and niobium are elements effective in precipitation hardening of steel and can be added as necessary. However, if each of the contents thereof is more than 0.1%, the formability and the shape fixability are degraded. Furthermore, an increase in cost is brought about. Therefore, in the case where Ti and Nb are added, the content of each of them is 0.1% or less. In this regard, so that the above-described effects are effectively exerted, each of the contents of Ti and Nb is preferably 0.01% or more.

Boron functions to suppress generation and growth of ferrite from austenite grain boundaries and, therefore, can be added as necessary. However, if 0.0050% is exceeded, formability is degraded. Furthermore, an increase in cost is brought about. Therefore, in the case where B is added, the content thereof is 0.0050% or less. In this regard, so that the above-described effects are effectively exerted, the content thereof is preferably 0.0003% or more.

(j) at Least One Type Selected from Ca: 0.005% or Less and REM: 0.005% or Less

Calcium and REM (Rare Earth Metal) are elements effective in spheroidizing the shape of a sulfide to improve an adverse influence of the sulfide on the hole expansion property. However, if the content is excessive, increases in inclusions and the like are caused and lead to surface and internal defects and the like. Therefore, in the case where Ca and REM are added, each of the contents thereof is 0.005% or less. In this regard, so that the above-described effects are effectively exerted, each of the content thereof is preferably 0.001% or more.

(2) Next, a steel microstructure will be described.

(a) Area Ratio of Ferrite Phase: 75% or More

To ensure good ductility, it is necessary that a ferrite phase be 75% or more on an area ratio basis.

(b) Area Ratio of Bainitic Ferrite Phase: 1.0% or More

It is necessary to reduce a hardness difference between the mild ferrite and the hard martensite to ensure good hole expansion property. Consequently, it is necessary that the area ratio of bainitic ferrite phase be 1.0% or more.

(c) Area Ratio of Pearlite Phase: 1.0% or More and Less than 10.0%

The area ratio of pearlite phase is specified to be 1.0% or more to ensure good hole expansion property. To ensure predetermined balance between the strength and the ductility, the area ratio of pearlite phase is 10.0% or less.

(d) Area Ratio of Martensite Phase: 1.0% or More and Less than 5.0%

The area ratio of martensite phase is specified to be 1.0% or more to ensure predetermined balance between the strength and the ductility. To ensure good stability of mechanical properties, it is necessary that the area ratio of martensite phase having a large influence on the tensile characteristics (TS, EL) is less than 5.0%.

(e) Area Ratio of Martensite Phase/(Area Ratio of Bainitic Ferrite Phase+Area Ratio of Pearlite phase) ≤ 0.6

To ensure good stability of mechanical properties, it is necessary that, in the phase configuration of the secondary phase, the amount of martensite, which causes variations in mechanical properties, be reduced and the amounts of bainitic ferrite and pearlite milder than martensite be increased, i.e., the area ratio of martensite phase/(area ratio of bainitic ferrite phase+area ratio of pearlite phase) ≤ 0.6 be satisfied.

Meanwhile, retained austenite, tempered martensite, and carbides, e.g., cementite, may be generated besides ferrite, bainitic ferrite, pearlite, and martensite. However, our purposes can be achieved insofar as the above-described area ratios of ferrite, bainitic ferrite, pearlite, and martensite phases are satisfied.

In this regard, the area ratios of ferrite, bainitic ferrite, pearlite, and martensite phases refer to proportions of the areas of the individual phases constituting an observation area.

Our high strength galvanized steel sheet includes the steel sheet having the above-described component composition and the above-described steel microstructure and serving as a substrate steel sheet and a coating film through galvanization or a coating film subjected to an alloying treatment after the galvanization on the substrate steel sheet.

(3) Next, Production Conditions Will be Described.

The high strength galvanized steel sheet is produced by subjecting a steel sheet obtained from a steel having the component composition conforming to the above-described component composition range to two steps of heating treatments described below and, thereafter, subjecting to a galvanization treatment or further subjecting to an alloying treatment after the galvanization treatment.

(a) Production of Steel Sheet

A steel having the above-described component composition is produced by melting, made into a slab through roughing slabbing or continuous casting, and made into a hot rolled steel sheet through hot rolling by a known method. In performing hot rolling, it is preferable that the slab be heated to 1,100° C. to 1,300° C., and hot rolled at a final finishing temperature of 850° C. or higher, and the resulting steel sheet be coiled at 400° C. to 650° C. In the case where the coiling temperature exceeds 650° C., carbides in the hot rolled steel sheet may become coarse and required strength may not be

obtained in some cases because such coarse carbides are not dissolved completely during soaking in annealing. Subsequently, a pickling treatment is performed by a known method. The hot rolled steel sheet thus obtained may be used as the above-described steel sheet, or the hot rolled steel sheet after pickling is performed may be further cold-rolled and the resulting cold rolled steel sheet may be used as the above-described steel sheet. In performing the cold rolling, the condition thereof is not necessarily specifically limited, although it is preferable that the cold rolling is performed at the cold reduction ratio of 30% or more. This is because if the cold reduction ratio is low, in some cases, recrystallization of ferrite is not facilitated, unrecrystallized ferrite remains, and the ductility and the hole expansion property are degraded.

(b) Heating Treatment

(i) First Heating Step

As for a first heating step, in the former part, the steel sheet is heated in an atmosphere containing O₂: 0.1 to 20 percent by volume and H₂O: 1 to 50 percent by volume such that the temperature thereof becomes 400° C. to 750° C. and, in the latter part, the steel sheet is heated in an atmosphere containing O₂: 0.01 to less than 0.1 percent by volume and H₂O: 1 to 20 percent by volume such that the temperature thereof becomes 600° C. to 850° C.

First Heating Step Former Part

The first heating step former part is performed to oxidize the steel sheet, and the O₂ is 0.1 percent by volume or more because an amount sufficient to induce oxidation is required. In this regard, O₂ is preferably 20 percent by volume or less, which is the same level as the air, for reason of economy. To facilitate oxidation, H₂O is 1 percent by volume or more. In this regard, H₂O is preferably 50 percent by volume or less in consideration of a humidification cost. In the step of the former part, if the temperature after the heating is lower than 400° C., oxidation is not induced easily. If the temperature is higher than 750° C., oxidation is induced excessively and iron oxide is peeled by a roll in a second heating step. Therefore, in the former part, heating is performed such that the steel sheet temperature becomes 400° C. or higher and 750° C. or lower.

First Heating Step Latter Part

The first heating step latter part is performed to reduce the steel sheet surface which has been oxidized once and suppress an occurrence of bruise. For that purpose, the heating in the latter part is performed under the condition in which the steel sheet surface can be reduced, but peeling of iron oxide does not occur, that is, the condition of low-temperature reduction heating in a low-oxygen concentration atmosphere to reduce the steel sheet surface, which has been oxidized once in the former part, to such an extent that peeling of iron oxide does not occur in the following second heating step. In this case, O₂ is less than 0.1 percent by volume because reduction cannot be induced when O₂ is 0.1 percent by volume or more. However, 0.01 percent by volume or more of O₂ is necessary. If a large amount of H₂O is contained, the steel sheet is oxidized and, therefore, H₂O is 20 percent by volume or less. However, 1 percent by volume or more of H₂O is necessary. If the steel sheet temperature is lower than 600° C., reduction is not induced easily, and if the temperature is higher than 850° C., the heating cost increases. Therefore, in the latter part, heating is performed such that the steel sheet temperature is 600° C. or higher and 850° C. or lower.

In the case where the heating in the former part is performed with a direct fired furnace (DFF) or a non-oxidizing furnace (NOF), it is preferable that the heating be performed under the condition in which a C gas generated in a coke oven is used as a fuel gas and the air ratio is 1 or more and 1.3 or

less. This is because if the air ratio is less than 1, oxidation of the steel sheet is not induced and if the air ratio is more than 1.3, pick up occurs by excessive oxidation. Meanwhile, in the case where the heating in the latter part is performed with a direct fired furnace (DFF) or a non-oxidizing furnace (NOF), it is preferable that the heating be performed under the condition in which a C gas generated in a coke oven is used as a fuel gas and the air ratio is 0.6 or more and less than 1. This is because if the air ratio is 1 or more, iron oxide on the steel sheet surface cannot be reduced and if the air ratio is less than 0.6, the combustion efficiency decreases.

(ii) Second Heating Step

The second heating step is performed successively to the first heating step and induces reduction and adjusts the steel sheet microstructure, wherein holding of the steel sheet is performed in an atmosphere containing H₂: 1 to 50 percent by volume and having a dew point of 0° C. or lower at a temperature of 750° C. to 900° C. for 15 to 600 s, cooling to a temperature of 450° C. to 550° C. is performed, and holding is performed at a temperature of 450° C. to 550° C. for 10 to 200 s.

Atmosphere Containing H₂: 1 to 50 Percent by Volume and Having Dew Point of 0° C. or Lower

If H₂ is less than 1 percent by volume and the dew point is higher than 0° C., iron oxide generated in the first heating step is hardly reduced and, therefore, even if iron oxide sufficient to ensure wettability is generated in the first heating step, on the contrary, wettability is degraded. If H₂ is more than 50 percent by volume, an increase in cost is brought about. If the dew point is lower than -60° C., industrial implementation is difficult and, therefore, the dew point is preferably -60° C. or higher.

Holding in Temperature Range of 750° C. to 900° C. for 15 to 600 s

Annealing, which is holding the steel sheet at a temperature of 750° C. to 900° C., specifically in a single phase region of austenite or in a two-phase region of austenite and ferrite, for 15 to 600 s, is performed. In the case where the annealing temperature is lower than 750° C. or the holding time is less than 15 s, hard cementite in the steel sheet is not dissolved sufficiently so that the hole expansion property is degraded and, furthermore, a predetermined area ratio of martensite phase is not obtained, so that the ductility is degraded. On the other hand, if the annealing temperature is higher than 900° C., austenite grains grow significantly, it becomes difficult to ensure bainitic ferrite due to bainite transformation which occurs in the holding after cooling so that the hole expansion property is degraded. Moreover, the area ratio of martensite phase/(area ratio of bainitic ferrite phase+area ratio of pearlite phase) exceeds 0.6, so that good stability of mechanical properties is not obtained. In addition, if the holding time exceeds 600 s, austenite becomes coarse, it becomes difficult to ensure predetermined strength, and an increase in cost associated with large energy consumption may be brought about.

Holding in Temperature Range of 450° C. to 550° C. for 10 to 200 s

After the above-described annealing is performed, cooling to a temperature of 450° C. to 550° C. is performed, followed by holding at a temperature of 450° C. to 550° C. for 10 to 200 s. If the holding temperature is higher than 550° C. or the holding time becomes less than 10 s, bainite transformation is not facilitated, and the area ratio of bainitic ferrite phase becomes less than 1.0%, so that a predetermined hole expansion property is not obtained. Meanwhile, if the holding temperature becomes lower than 450° C. or the holding time exceeds 200 s, most of the secondary phase is converted to

austenite and bainitic ferrite, which are generated through facilitation of bainite transformation and which contain large amounts of carbon in solid solution. Then a predetermined area ratio of pearlite phase of 1.0% or more is not obtained and, furthermore, the area ratio of hard martensite phase becomes 5.0% or more so that good hole expansion property and stability of mechanical properties are not obtained.

(c) Galvanization Treatment

After the above-described second heating step, the steel sheet is dipped into a coating bath at a usual bath temperature to be galvanized, and the amount of deposition of coating is adjusted through gas wiping or the like, followed by cooling, so that a galvanized steel sheet having a coating layer not subjected to alloying is obtained.

In the case where a galvanized steel sheet subjected to an alloying treatment is produced, after the galvanization treatment is performed, the alloying treatment of zinc coating is performed at a temperature of 500° C. to 600° C. under the condition satisfying the following formula:

$$0.45 \leq \exp[200/(400-T)] \times \ln(t) \leq 1.0$$

where

T: average holding temperature (° C.) at a temperature of 500° C. to 600° C.,

t: holding time (s) at a temperature of 500° C. to 600° C., and

exp(X) and ln(X) represent an exponential function and natural logarithm, respectively, of X.

If $\exp[200/(400-T)] \times \ln(t)$ is less than 0.45, much martensite is present in a steel microstructure after the alloying treatment, the above-described hard martensite adjoins mild ferrite to cause a large hardness difference between different phases so that the hole expansion property is degraded. Furthermore, the area ratio of martensite phase/(area ratio of bainitic ferrite phase+area ratio of pearlite phase) is more than 0.6 and, thereby, the stability of mechanical properties is impaired. Moreover, deposition property of the galvanization layer is degraded. If $\exp[200/(400-T)] \times \ln(t)$ exceeds 1.0, most of untransformed austenite is transformed to cementite or pearlite and, as a result, predetermined balance between the strength and the ductility is not ensured.

Meanwhile, at a temperature lower than 500° C., alloying of the coating layer is not facilitated, and it is difficult to obtain a galvanized steel sheet. Also, at a temperature exceeding 600° C., most of the secondary phase is converted to pearlite so that a predetermined area ratio of martensite phase is not obtained and the balance between the strength and the ductility is degraded.

An alloying treatment is performed at a temperature of 500° C. to 600° C. such that $\exp[200/(400-T)] \times \ln(t)$ satisfies the above-described range and, thereby, a high strength galvanized steel sheet can be obtained without an occurrence of such problems.

A high strength galvanized steel sheet, which has a tensile strength TS of 540 MPa or more, which has excellent formability and stability of mechanical properties, and which also has excellent coating appearance, is thus obtained.

FIG. 1 and FIG. 2 are diagrams showing the organized relationships between the annealing temperature (T₁) and TS and between the annealing temperature (T₁) and EL in the second heating step with respect to Nos. 15, 16, and 17 of Steel A, which are our examples, (Table 2 and Table 5) and Nos. 18, 19, and 20 of Steel H, which are comparative examples, (Table 2 and Table 5) in Examples described later. Also, FIG. 3 and FIG. 4 are diagrams showing the organized relationships between the average holding temperature (T₂) during cooling after annealing and TS and between the aver-

age holding temperature (T_2) and EL in the second heating step with respect to Nos. 21, 22, and 23 of Steel A, which are our examples, (Table 2 and Table 5) and Nos. 24, 25, and 26 of Steel H, which are comparative examples, (Table 2 and Table 5) in Examples described later.

As is clear from FIGS. 1 and 2, variations in TS and EL associated with changes in annealing temperature of Steel A of our example are small, whereas variations in TS and EL of Steel H of the comparative example are large. Also, as is clear from FIGS. 3 and 4, variations in TS and EL associated with changes in average holding temperature of Steel A of our example are small, whereas variations in TS and EL of Steel H of the comparative example are large.

As is clear from the above-described results, a high strength galvanized steel sheet having high stability of mechanical properties is obtained according to our methods.

By the way, in a series of heat treatments in our manufacturing method, the holding temperature is not necessarily constant insofar as the temperature is in the above-described range. Furthermore, even in the case where the cooling rate is changed during cooling, there is no problem insofar as the rate is in the specified range. Moreover, the steel sheet may be subjected to a heat treatment by any equipment insofar as only the heat history specified in our method is satisfied. In addition, it is also in the scope of our methods that our steel sheets are subjected to temper rolling after the heat treatment for the purpose of shape correction.

In this regard, typically, the steel sheet is usually produced from a steel through the individual steps of steel making.

casting, hot rolling, and the like. However, for example, the steel sheet may be produced through thin wall casting or the like, where a part of or whole hot rolling step is omitted.

EXAMPLES

A steel having a component composition shown in Table 1, where the remainder was composed of Fe and incidental impurities, was produced by melting with a converter, and made into a slab by a continuous casting method. The resulting slab was heated to 1,200° C., then hot rolled to a sheet thickness of 3.2 mm at a finishing temperature of 870° C. to 920° C., and coiled at 520° C. Subsequently, the resulting hot rolled sheet was pickled to produce a hot rolled steel sheet. A part of the hot rolled steel sheet was served as a pickled hot rolled steel sheet, and the remainder was further subjected to cold rolling to produce a cold rolled steel sheet. Then, the hot rolled steel sheet after pickling and the cold rolled steel sheet obtained as described above were subjected to an annealing treatment, a galvanization treatment and, furthermore, an alloying treatment of the coating layer with a continuous galvanization line under the production condition shown in Tables 2 to 4 to obtain a galvanized steel sheet (galvanized steel with cold rolled steel sheet substrate: Nos. 1 to 90, galvanized steel with hot rolled steel sheet substrate: Nos. 91 and 92). The amount of deposition of coating was specified to be 30 to 50 g/m² on one surface basis. Galvanized steel sheets, which were not subjected to an alloying treatment after a galvanization treatment, were also produced partly.

TABLE 1

Steel	Chemical component (percent by mass)										
type	C	Si	Mn	Al	P	S	N	Ni	Cu	Cr	V
A	0.085	1.48	1.41	0.029	0.016	0.0020	0.0029	—	—	—	—
B	0.094	1.49	1.40	0.031	0.017	0.0021	0.0030	—	—	—	—
C	0.077	1.51	1.39	0.030	0.015	0.0022	0.0031	—	—	—	—
D	0.084	1.55	1.40	0.031	0.017	0.0021	0.0030	—	—	—	—
E	0.086	1.45	1.39	0.030	0.015	0.0022	0.0031	—	—	—	—
F	0.084	1.50	1.49	0.031	0.017	0.0021	0.0030	—	—	—	—
G	0.086	1.50	1.30	0.030	0.015	0.0022	0.0031	—	—	—	—
H	0.084	<u>0.24</u>	1.81	0.035	0.026	0.0020	0.0036	—	—	0.15	0.061
I	0.094	<u>0.25</u>	1.80	0.035	0.026	0.0020	0.0036	—	—	0.16	0.062
J	0.076	<u>0.25</u>	1.79	0.035	0.026	0.0020	0.0036	—	—	0.16	0.062
K	0.086	<u>0.29</u>	1.80	0.035	0.026	0.0020	0.0036	—	—	0.14	0.060
L	0.085	<u>0.20</u>	1.80	0.035	0.026	0.0020	0.0036	—	—	0.16	0.059
M	0.085	<u>0.23</u>	1.91	0.035	0.026	0.0020	0.0036	—	—	0.15	0.059
N	0.085	<u>0.23</u>	1.72	0.035	0.026	0.0020	0.0036	—	—	0.15	0.058
O	0.104	1.37	1.22	0.031	0.012	0.0019	0.0036	—	—	—	—
P	0.055	1.53	1.68	0.032	0.021	0.0027	0.0039	—	—	—	—
Q	0.092	0.98	1.63	0.039	0.023	0.0028	0.0032	—	—	—	—
R	0.076	1.47	1.32	0.028	0.018	0.0019	0.0035	—	—	0.18	—
S	0.079	1.55	1.38	0.026	0.012	0.0018	0.0031	—	—	—	0.055
T	0.090	1.41	1.32	0.030	0.013	0.0030	0.0030	—	—	—	—
U	0.085	1.52	1.42	0.026	0.008	0.0025	0.0032	—	—	—	—
V	0.081	1.46	1.35	0.029	0.011	0.0027	0.0029	—	—	—	—
W	0.076	1.52	1.19	0.031	0.018	0.0023	0.0036	0.21	0.14	—	—
X	0.093	1.46	1.33	0.030	0.009	0.0030	0.0033	—	—	—	—
Y	<u>0.151</u>	1.42	1.50	0.039	0.022	0.0026	0.0034	—	—	—	—
Z	0.102	<u>0.39</u>	1.71	0.030	0.019	0.0028	0.0031	—	—	—	—
AA	0.056	1.22	<u>2.39</u>	0.028	0.016	0.0019	0.0033	—	—	—	—

[illegible]

TABLE 1-continued

H	—	—	—	—	—	—	Comparative example
I	—	—	—	—	—	—	Comparative example
J	—	—	—	—	—	—	Comparative example
K	—	—	—	—	—	—	Comparative example
L	—	—	—	—	—	—	Comparative example
M	—	—	—	—	—	—	Comparative example
N	—	—	—	—	—	—	Comparative example
O	—	—	—	—	—	—	Invention example
P	—	—	—	—	—	—	Invention example
Q	—	—	—	—	—	—	Invention example
R	—	—	—	—	—	—	Invention example
S	—	—	—	—	—	—	Invention example
T	0.046	—	—	—	—	—	Invention example
U	—	0.021	—	—	—	—	Invention example
V	—	—	0.019	0.0020	—	—	Invention example
W	—	—	—	—	—	—	Invention example
X	—	—	—	—	0.0020	0.0010	Invention example
Y	—	—	—	—	—	—	Comparative example
Z	—	—	—	—	—	—	Comparative example
AA	—	—	—	—	—	—	Comparative example

Underlined portion: out of the scope of the present invention

TABLE 2

No.	Steel type	First heating step former part					First heating step latter part					Second heating step				
		O ₂ %	H ₂ O %	Others	Heating		O ₂ %	H ₂ O %	Others	Heating		Furnace type	H ₂ %	Dew point		
					tempera- ture ° C.	Air ratio				tempera- ture ° C.	Air ratio			° C.	Others	
1	A	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	−35	N ₂ , CO ₂ , CO	
2	B	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	−35	N ₂ , CO ₂ , CO	
3	C	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	−35	N ₂ , CO ₂ , CO	
4	D	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	−35	N ₂ , CO ₂ , CO	
5	E	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	−35	N ₂ , CO ₂ , CO	
6	F	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	−35	N ₂ , CO ₂ , CO	
7	G	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	−35	N ₂ , CO ₂ , CO	
8	H	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	−35	N ₂ , CO ₂ , CO	
9	I	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	−35	N ₂ , CO ₂ , CO	
10	J	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	−35	N ₂ , CO ₂ , CO	
11	K	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	−35	N ₂ , CO ₂ , CO	
12	L	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	−35	N ₂ , CO ₂ , CO	
13	M	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	−35	N ₂ , CO ₂ , CO	
14	N	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	−35	N ₂ , CO ₂ , CO	
15	A	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	−35	N ₂ , CO ₂ , CO	
16	A	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	−35	N ₂ , CO ₂ , CO	
17	A	2	15	N ₂ , CO ₂ , CO, H ₂	680	1.15	0.01	5	N ₂ , CO ₂ , CO	700	0.85	DFF	10	−35	N ₂ , CO ₂ , CO	
18	H	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	−35	N ₂ , CO ₂ , CO	
19	H	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	−35	N ₂ , CO ₂ , CO	
20	H	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	−35	N ₂ , CO ₂ , CO	
21	A	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	−35	N ₂ , CO ₂ , CO	
22	A	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	−35	N ₂ , CO ₂ , CO	

TABLE 2-continued

23	A	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
24	H	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
25	H	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
26	H	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
27	A	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
28	A	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
29	A	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
30	A	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO

Second heating step

No.	Heating tempera- ture T ₁ ° C.	Annealing time s	Average holding temperature after cooling up to dipping into coating bath T ₂ ° C.	Holding time after cooling up to dipping into coating bath s	Average holding tempera- ture: T ° C.	Holding time: t s	$\exp(200/(400 - T)) \times$ In(t)	Remarks
1	855	160	495	60	570	15	0.835	Invention example
2	855	160	495	60	570	15	0.835	Invention example
3	855	160	495	60	570	15	0.835	Invention example
4	855	160	495	60	570	15	0.835	Invention example
5	855	160	495	60	570	15	0.835	Invention example
6	855	160	495	60	570	15	0.835	Invention example
7	855	160	495	60	570	15	0.835	Invention example
8	830	160	495	60	520	15	0.511	Comparative example
9	830	160	495	60	520	15	0.511	Comparative example
10	830	160	495	60	520	15	0.511	Comparative example
11	830	160	495	60	520	15	0.511	Comparative example
12	830	160	495	60	520	15	0.511	Comparative example
13	830	160	495	60	520	15	0.511	Comparative example
14	830	160	495	60	520	15	0.511	Comparative example
15	850	160	495	60	570	15	0.835	Invention example
16	800	160	495	60	570	15	0.835	Invention example
17	750	160	495	60	570	15	0.835	Invention example
18	850	160	495	60	520	15	0.511	Comparative example
19	800	160	495	60	520	15	0.511	Comparative example
20	750	160	495	60	520	15	0.511	Comparative example
21	850	160	530	60	570	15	0.835	Invention example
22	850	160	500	60	570	15	0.835	Invention example
23	850	160	470	60	570	15	0.835	Invention example
24	830	160	530	60	520	15	0.511	Comparative example
25	830	160	500	60	520	15	0.511	Comparative example
26	830	160	470	60	520	15	0.511	Comparative example
27	860	120	500	40	580	10	0.758	Invention example
28	780	120	500	40	580	10	0.758	Invention example
29	840	280	530	100	555	25	0.886	Invention example
30	840	280	470	100	555	25	0.886	Invention example

Underlined portion: out of the scope of the present invention

TABLE 3

First heating step former part							First heating step latter part						Second heating step			
Heating							Heating									
No.	Steel type	O ₂ %	H ₂ O %	Others	tempera- ture ° C.	Air ratio	O ₂ %	H ₂ O %	Others	tempera- ture ° C.	Air ratio	Furnace type	H ₂ %	Dew point ° C.	Others	
31	A	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO	
32	A	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO	
33	O	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO	

TABLE 3-continued

34	O	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
35	O	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
36	A	2	15	N ₂ , CO ₂ , CO, H ₂	750	1.15	0.01	5	N ₂ , CO ₂ , CO	800	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
37	A	2	15	N ₂ , CO ₂ , CO, H ₂	680	1.15	0.01	5	N ₂ , CO ₂ , CO	700	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
38	A	0.5	15	N ₂ , CO ₂ , CO, H ₂	700	1.10	0.01	5	N ₂ , CO ₂ , CO	720	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
39	A	0.5	15	N ₂ , CO ₂ , CO, H ₂	680	1.10	0.01	5	N ₂ , CO ₂ , CO	700	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
40	A	0.5	15	N ₂ , CO ₂ , CO, H ₂	600	1.10	0.01	5	N ₂ , CO ₂ , CO	650	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
41	A	0.1	15	N ₂ , CO ₂ , CO, H ₂	680	1.05	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
42	A	8	15	N ₂ , CO ₂ , CO, H ₂	680	1.25	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
43	A	0.1	15	N ₂ , CO ₂ , CO, H ₂	550	1.05	0.01	5	N ₂ , CO ₂ , CO	630	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
44	A	0.1	15	N ₂ , CO ₂ , CO, H ₂	480	1.05	0.01	5	N ₂ , CO ₂ , CO	610	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
45	A	2	15	N ₂ , CO ₂ , CO, H ₂	750	1.15	0.01	5	N ₂ , CO ₂ , CO	<u>880</u>	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
46	A	2	15	N ₂ , CO ₂ , CO, H ₂	450	1.15	0.01	5	N ₂ , CO ₂ , CO	<u>470</u>	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
47	A	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	<u>2</u>	15	N ₂ , CO ₂ , CO	750	<u>1.15</u>	DFF	10	-35	N ₂ , CO ₂ , CO
48	A	2	15	N ₂ , CO ₂ , CO, H ₂	700	<u>0.85</u>	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
49	A	10	15	N ₂ , CO ₂ , CO, H ₂	660	<u>1.35</u>	0.01	5	N ₂ , CO ₂ , CO	680	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
50	A	2	15	N ₂ , CO ₂ , CO, H ₂	660	1.15	0.01	5	N ₂ , CO ₂ , CO	680	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
51	O	2	15	N ₂ , CO ₂ , CO, H ₂	570	1.15	0.01	5	N ₂ , CO ₂ , CO	600	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
52	O	2	15	N ₂ , CO ₂ , CO, H ₂	<u>800</u>	1.15	0.01	5	N ₂ , CO ₂ , CO	850	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
53	P	2	15	N ₂ , CO ₂ , CO, H ₂	750	1.15	0.01	5	N ₂ , CO ₂ , CO	800	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
54	P	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
55	P	2	15	N ₂ , CO ₂ , CO, H ₂	740	1.15	0.01	5	N ₂ , CO ₂ , CO	780	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
56	P	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
57	P	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
58	P	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
59	Q	0.5	15	N ₂ , CO ₂ , CO, H ₂	650	1.10	0.01	5	N ₂ , CO ₂ , CO	700	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
60	Q	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO

Second heating step

No.	Heating temperature T ₁ ° C.	Annealing time s	Average holding temperature after cooling up to dipping into coating bath T ₂ ° C.	Holding time after cooling up to dipping into coating bath s	Average holding temperature: T ° C.	Holding time: t s	$\exp(200/(400 - T)) \times \ln(t)$	Remarks
31	840	180	480	120	—	—	—	Invention example
32	780	180	480	120	—	—	—	Invention example
33	850	165	520	60	565	15	0.806	Invention example
34	850	165	470	60	565	15	0.806	Invention example
35	800	160	495	50	545	15	0.682	Comparative example
36	855	160	495	60	570	15	0.835	Invention example
37	855	160	495	60	570	15	0.835	Invention example
38	750	160	495	60	520	15	0.511	Invention example
39	750	160	495	60	520	15	0.511	Invention example
40	750	160	495	60	520	15	0.511	Invention example
41	750	160	495	60	520	15	0.511	Invention example
42	750	160	495	60	520	15	0.511	Invention example
43	750	280	530	100	555	25	0.886	Invention example
44	750	280	530	100	555	25	0.886	Invention example

TABLE 3-continued

45	900	160	495	60	570	15	0.835	Comparative example
46	750	160	530	100	555	25	0.886	Comparative example
47	855	160	495	60	570	15	0.835	Comparative example
48	855	160	495	60	570	15	0.835	Comparative example
49	855	160	495	60	570	15	0.835	Comparative example
50	<u>700</u>	160	495	60	570	15	0.835	Comparative example
51	<u>650</u>	180	500	60	555	15	0.745	Comparative example
52	<u>935</u>	230	485	65	570	15	0.835	Comparative example
53	860	180	490	55	575	12	0.792	Invention example
54	780	180	490	55	575	12	0.792	Invention example
55	830	<u>850</u>	505	55	580	12	0.818	Comparative example
56	840	<u>5</u>	495	45	570	12	0.766	Comparative example
57	860	160	<u>600</u>	45	570	12	0.766	Comparative example
58	810	170	<u>130</u>	60	560	12	0.712	Comparative example
59	845	190	520	70	565	18	0.860	Invention example
60	830	200	480	<u>4</u>	555	18	0.795	Comparative example

Underlined portion: out of the scope of the present invention

TABLE 4

No.	Steel type	First heating step former part					First heating step latter part					Second heating step			
		O ₂ %	H ₂ O %	Others	Heating		O ₂ %	H ₂ O %	Others	Heating		Furnace type	H ₂ %	Dew point	
					tempera- ture ° C.	Air ratio				tempera- ture ° C.	Air ratio			° C.	Others
61	Q	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
62	Q	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
63	Q	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
64	Q	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
65	Q	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
66	R	0.5	15	N ₂ , CO ₂ , CO, H ₂	650	1.10	0.01	5	N ₂ , CO ₂ , CO	700	0.85	NOF	10	-35	N ₂ , CO ₂ , CO
67	R	2	15	N ₂ , CO ₂ , CO, H ₂	640	1.15	0.01	5	N ₂ , CO ₂ , CO	680	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
68	R	2	15	N ₂ , CO ₂ , CO, H ₂	500	1.15	0.01	5	N ₂ , CO ₂ , CO	620	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
69	S	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
70	T	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	730	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
71	U	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
72	U	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	720	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
73	U	2	15	N ₂ , CO ₂ , CO, H ₂	650	1.15	0.01	5	N ₂ , CO ₂ , CO	680	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
74	V	2	15	N ₂ , CO ₂ , CO, H ₂	600	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
75	W	2	15	N ₂ , CO ₂ , CO, H ₂	720	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	NOF	10	-35	N ₂ , CO ₂ , CO
76	X	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
77	X	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
78	X	2	15	N ₂ , CO ₂ , CO, H ₂	680	1.15	0.01	5	N ₂ , CO ₂ , CO	700	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
79	Y	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	820	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
80	Y	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
81	Y	2	15	N ₂ , CO ₂ , CO, H ₂	600	1.15	0.01	5	N ₂ , CO ₂ , CO	680	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
82	Z	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
83	Z	2	15	N ₂ , CO ₂ , CO, H ₂	750	1.15	0.01	5	N ₂ , CO ₂ , CO	780	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
84	Z	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO

TABLE 4-continued

85	AA	0.5	15	N ₂ , CO ₂ , CO, H ₂	680	1.10	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
86	AA	2	15	N ₂ , CO ₂ , CO, H ₂	700	1.15	0.01	5	N ₂ , CO ₂ , CO	750	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
87	AA	2	15	N ₂ , CO ₂ , CO, H ₂	600	1.15	0.01	5	N ₂ , CO ₂ , CO	680	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
88	A	0.1	15	N ₂ , CO ₂ , CO, H ₂	650	1.05	0.01	5	N ₂ , CO ₂ , CO	700	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
89	A	0.1	15	N ₂ , CO ₂ , CO, H ₂	650	1.05	0.01	5	N ₂ , CO ₂ , CO	700	0.85	NOF	10	-35	N ₂ , CO ₂ , CO
90	A	0.1	15	N ₂ , CO ₂ , CO, H ₂	520	1.05	0.01	5	N ₂ , CO ₂ , CO	600	0.85	DFF	10	-35	N ₂ , CO ₂ , CO
91	A	0.1	15	N ₂ , CO ₂ , CO, H ₂	540	1.05	0.01	5	N ₂ , CO ₂ , CO	600	0.85	NOF	10	-35	N ₂ , CO ₂ , CO
92	A	0.1	15	N ₂ , CO ₂ , CO, H ₂	520	1.05	0.01	5	N ₂ , CO ₂ , CO	600	0.85	DFF	10	-35	N ₂ , CO ₂ , CO

Second heating step

No.	Heating tempera- ture T ₁ ° C.	Annealing time s	Average holding temperature after cooling up to dipping into coating bath T ² ° C.	Holding time after cooling up to dipping into coating bath s	Average holding tempera- ture: T ° C.	Holding time: t s	$\exp(200/(400 - T)) \times$ In(t)	Remarks
61	845	180	510	410	560	18	0.828	Comparative example
62	840	200	510	55	570	40	1.138	Comparative example
63	845	170	520	60	510	6	0.291	Comparative example
64	810	190	490	70	660	18	1.339	Comparative example
65	820	210	485	65	470	18	0.166	Comparative example
66	860	230	495	90	555	22	0.851	Invention example
67	820	230	495	90	555	22	0.851	Invention example
68	790	220	495	85	555	22	0.851	Invention example
69	840	200	495	75	560	20	0.858	Invention example
70	840	100	500	45	575	11	0.765	Invention example
71	840	190	520	65	555	18	0.795	Invention example
72	810	190	520	70	555	18	0.795	Invention example
73	780	200	520	65	555	18	0.795	Invention example
74	825	260	510	110	550	26	0.859	Invention example
75	840	110	540	40	580	9	0.723	Invention example
76	850	170	495	60	570	14	0.814	Invention example
77	820	180	495	60	570	14	0.814	Invention example
78	790	180	495	60	570	14	0.814	Invention example
79	870	160	490	55	570	15	0.835	Comparative example
80	800	160	490	55	570	15	0.835	Comparative example
81	750	160	490	55	570	15	0.835	Comparative example
82	860	180	540	60	560	15	0.776	Comparative example
83	860	180	500	60	560	15	0.776	Comparative example
84	860	180	470	60	560	15	0.776	Comparative example
85	850	210	500	45	575	12	0.792	Comparative example
86	800	210	500	45	575	12	0.792	Comparative example
87	750	210	500	45	575	12	0.792	Comparative example
88	850	160	495	60	555	25	0.886	Invention example
89	800	160	495	60	555	25	0.886	Invention example
90	750	160	495	60	555	25	0.886	Invention example
91	850	160	495	60	555	25	0.886	Invention example
92	850	160	495	60	555	25	0.886	Invention example

Underlined portion: out of the scope of the present invention

The area ratios of ferrite, bainitic ferrite, pearlite, and martensite phases of the resulting galvanized steel sheet were determined by polishing a sheet thickness cross-section parallel to a rolling direction of the steel sheet, performing etching with 3% nital, and observing 10 visual fields with a SEM (scanning electron microscope) at a magnification of 2,000 times through the use of Image-Pro of Media Cybernetics, Inc. At that time, it was difficult to distinguish martensite and retained austenite. Therefore, the resulting galvanized steel sheet was subjected to a tempering treatment at 200° C. for 2 hours. Thereafter, the microstructure of a sheet thickness cross-section parallel to the rolling direction of the steel sheet was observed by the above-described method, and the area

ratio of tempered martensite phase determined by the above-described method was taken as the area ratio of martensite phase.

Meanwhile, the volume ratio of retained austenite phase was determined on the basis of diffracted X-ray intensity of a face at one-quarter sheet thickness, where the steel sheet was grounded up to the one-quarter face in the sheet thickness direction. The Co—K α line was used as the incident X-ray, the intensity ratios were determined with respect to all combinations of integrated intensities of peaks of {111}, {200}, {220}, and {311} planes of retained austenite phase and {110}, {200}, and {211} planes of ferrite phase, and the average value of them was taken as the volume ratio of retained austenite phase.

Meanwhile, a tensile test was performed on the basis of JIS Z 2241 by using JIS No. 5 test piece, where a sample was taken such that a tensile direction became in the direction orthogonal to the rolling direction of the steel sheet, the TS (tensile strength) and the EL (total elongation) were measured, and the case of $TS \times EL \geq 19,000$ MPa·% was evaluated as good ductility.

As for the stability of mechanical properties, (A) amounts of variations in TS and EL were examined with respect to steel sheets, where only the annealing temperatures T_1 were different and the conditions other than the annealing temperature T_1 were the same, and the amounts of variations (ΔTS and ΔEL) relative to 20° C. of change in the annealing temperature were determined from the resulting amounts of variations in TS and EL, in addition, (B) amounts of variations in TS and EL were examined with respect to steel sheets, where only the average holding temperatures T_2 after the cooling up to the dipping into a coating bath were different and the conditions other than the average holding temperatures T_2 after the cooling up to the dipping into a coating bath were the same, and the amounts of variations (ΔTS and ΔEL) relative to 20° C. of change in the average holding temperature after the cooling up to the dipping into a coating bath were determined from the resulting amounts of variations in TS and EL, and the evaluation was performed on the basis of each of the amounts of variations in TS (ΔTS) and the amounts of variations in EL (ΔEL) relative to the 20° C. of temperature change.

In addition, the hole expansion property (stretch flangeability) of the galvanized steel sheet obtained as described above was measured. The hole expansion property (stretch

flangeability) was measured on the basis of the Japan Iron and Steel Federation Standard JFST1001. Each of the resulting steel sheets was cut into 100 mm×100 mm, and a hole having a diameter of 10 mm was punched with a clearance of $12\% \pm 1\%$ when the sheet thickness was 2.0 mm or more and with a clearance of $12\% \pm 2\%$ when the sheet thickness was less than 2.0 mm. Thereafter, a 60° cone punch was pushed into the hole while being held with a blank holder pressure of 9 ton by using a dice having an inside diameter of 75 mm, a hole diameter at the limit of occurrence of cracking was measured, a critical hole expansion ratio λ (%) was determined from the following formula, and the stretch flangeability was evaluated on the basis of the value of the resulting critical hole expansion ratio, and the case of $\lambda \geq 70(\%)$ was evaluated as good:

$$\text{Critical hole expansion ratio } \lambda(\%) = \frac{(D_f - D_0)}{D_0} \times 100$$

where D_f represents a hole diameter (mm) when cracking occurred and D_0 represents an initial hole diameter (mm).

Meanwhile, the surface appearance was examined by a method described below.

Presence or absence of appearance defects, e.g., non-coating and bruise, was visually determined. The case where there was no appearance defect was evaluated as good (○), the case where there were a few appearance defects, but most part were good was evaluated as good for the most part (Δ), and the case where there were appearance defects was evaluated as poor (x).

The results obtained as described above are shown in Tables 5 to 7.

TABLE 5

No.	Steel type	Sheet thickness (mm)	Area ratio of F (%)	Area ratio of M (%)	Area ratio of BF (%)	Area ratio of P (%)	Volume ratio of RA (%)	M/(BF + P)	TS (MPa)	EL (%)	λ (%)
1	A	1.4	87.6	2.2	3.6	4.4	1.2	0.28	626	32.9	102
2	B	1.4	84.1	3.5	4.2	5.1	2.2	0.38	645	32.4	89
3	C	1.4	88.9	1.7	3.2	4.1	0.8	0.23	611	33.2	111
4	D	1.4	88.8	1.8	4.1	3.2	1.2	0.25	632	33.2	98
5	E	1.4	86.2	3.0	3.6	4.8	0.9	0.36	623	33.1	104
6	F	1.4	85.7	3.8	3.6	3.2	2.2	0.56	645	32.4	88
7	G	1.4	88.2	1.5	4.0	4.9	0.7	0.17	609	33.4	110
8	H	1.4	83.9	<u>13.2</u>	<u>0.8</u>	<u>0.7</u>	0.7	<u>8.80</u>	624	27.6	<u>53</u>
9	I	1.4	82.5	<u>14.8</u>	<u>0.5</u>	<u>0.4</u>	0.8	<u>16.4</u>	689	25.2	<u>44</u>
10	J	1.4	86.8	<u>10.7</u>	<u>0.7</u>	<u>0.3</u>	0.7	<u>10.7</u>	589	29.5	<u>60</u>
11	K	1.4	84.5	<u>13.0</u>	<u>0.8</u>	<u>0.7</u>	0.5	<u>8.67</u>	630	27.8	<u>49</u>
12	L	1.4	83.4	<u>14.7</u>	<u>0.6</u>	<u>0.4</u>	0.5	<u>14.70</u>	618	27.8	<u>52</u>
13	M	1.4	81.9	<u>15.2</u>	<u>0.9</u>	<u>0.4</u>	1.1	<u>11.69</u>	691	26.0	<u>45</u>
14	N	1.4	84.4	<u>12.4</u>	<u>0.9</u>	<u>0.6</u>	0.6	<u>8.27</u>	601	28.6	<u>55</u>
15	A	1.4	87.6	2.4	3.6	5.1	0.9	0.28	612	33.6	110
16	A	1.4	87.4	2.3	3.7	5.0	1.1	0.26	621	33.2	105
17	A	1.4	87.5	2.2	3.6	4.8	1.3	0.26	630	33.0	103
18	H	1.4	84.9	<u>12.2</u>	<u>0.8</u>	<u>0.8</u>	0.5	<u>7.63</u>	608	28.1	<u>58</u>
19	H	1.4	83.8	<u>13.2</u>	<u>0.7</u>	<u>0.8</u>	0.6	<u>8.80</u>	649	26.8	<u>50</u>
20	H	1.4	82.8	<u>14.1</u>	<u>0.6</u>	<u>0.6</u>	0.7	<u>11.75</u>	688	24.9	<u>42</u>
21	A	1.4	87.6	2.4	3.6	4.7	1.2	0.29	632	33.1	99
22	A	1.4	87.9	2.1	3.8	4.8	1.0	0.24	627	33.3	103
23	A	1.4	87.4	2.0	4.1	4.7	1.3	0.23	622	33.6	112
24	H	1.4	83.1	<u>13.9</u>	<u>0.7</u>	<u>0.7</u>	0.7	<u>9.93</u>	661	26.5	<u>48</u>
25	H	1.4	84.1	<u>13.2</u>	<u>0.8</u>	<u>0.5</u>	0.9	<u>10.15</u>	628	28.2	<u>54</u>
26	H	1.4	84.8	<u>12.3</u>	<u>0.8</u>	<u>0.6</u>	1.0	<u>8.79</u>	599	29.1	<u>61</u>
27	A	0.8	85.6	3.8	4.9	2.7	2.1	0.50	648	31.5	89
28	A	0.8	84.5	4.2	5.2	2.6	2.5	0.54	659	30.8	86
29	A	2.3	86.1	2.1	4.8	5.8	0.5	0.20	606	35.2	111
30	A	2.3	85.9	1.8	5.4	6.0	0.4	0.16	600	35.8	123

	TS × EL	$\frac{\Delta T_1}{\Delta 20^\circ \text{C.}}$		$\frac{\Delta T_2}{\Delta 20^\circ \text{C.}}$		Surface			
		No.	(MPa · %)	ΔTS	ΔEL	ΔTS	ΔEL	appearance	Remarks
1	20595	—	—	—	—	—	—	○	Invention example
2	20898	—	—	—	—	—	—	○	Invention example
3	20285	—	—	—	—	—	—	○	Invention example

TABLE 5-continued

4	20982	—	—	—	—	○	Invention example
5	20621	—	—	—	—	○	Invention example
6	20898	—	—	—	—	○	Invention example
7	20341	—	—	—	—	○	Invention example
8	<u>17222</u>	—	—	—	—	○	Comparative example
9	<u>17363</u>	—	—	—	—	○	Comparative example
10	<u>17376</u>	—	—	—	—	○	Comparative example
11	<u>17514</u>	—	—	—	—	○	Comparative example
12	<u>17180</u>	—	—	—	—	○	Comparative example
13	<u>17966</u>	—	—	—	—	○	Comparative example
14	<u>17189</u>	—	—	—	—	○	Comparative example
15	20563	3.6	0.12	—	—	○	Invention example
16	20617	—	—	—	—	○	Invention example
17	20790	—	—	—	—	○	Invention example
18	<u>17085</u>	16.0	0.64	—	—	○	Comparative example
19	<u>17393</u>	—	—	—	—	○	Comparative example
20	<u>17131</u>	—	—	—	—	○	Comparative example
21	20919	—	—	3.3	0.16	○	Invention example
22	20879	—	—	—	—	○	Invention example
23	20899	—	—	—	—	○	Invention example
24	<u>17517</u>	—	—	20.6	0.86	○	Comparative example
25	<u>17710</u>	—	—	—	—	○	Comparative example
26	<u>17431</u>	—	—	—	—	○	Comparative example
27	20412	3.6	0.26	—	—	○	Invention example
28	20297	—	—	—	—	○	Invention example
29	21331	—	—	2.0	0.20	○	Invention example
30	21480	—	—	—	—	○	Invention example

Underlined portion: out of the scope of the present invention

F: ferrite, M: martensite, BF: bainitic ferrite, P: pearlite, RA: retained austenite

M/(BF + P): Area ratio of M/(Area ratio of BF + Area ratio of P)

TABLE 6

No.	Steel type	Sheet thickness (mm)	Area ratio of F (%)	Area ratio of M (%)	Area ratio of BF (%)	Area ratio of P (%)	Volume ratio of RA (%)	M/(BF + P)	TS (MPa)	EL (%)	λ (%)
31	A	1.4	83.8	4.2	6.4	1.8	3.1	0.51	654	34.1	87
32	A	1.4	84.2	4.4	6.5	1.7	2.8	0.54	661	34.2	84
33	O	1.4	84.9	3.5	5.4	4.9	0.8	0.34	648	32.4	92
34	O	1.4	83.9	3.7	5.8	5.1	1.1	0.34	640	32.8	97
35	O	1.4	85.1	<u>6.8</u>	2.2	3.2	1.8	<u>1.26</u>	628	30.6	<u>67</u>
36	A	1.4	87.8	2.1	3.8	4.1	1.4	0.27	628	33.2	96
37	A	1.4	87.6	2.4	3.9	4.2	1.3	0.30	624	32.8	101
38	A	1.4	88.4	3.4	2.9	3.6	1.0	0.52	620	31.8	79
39	A	1.4	88.9	3.2	2.9	3.4	0.9	0.51	611	32.4	80
40	A	1.4	88.2	3.6	3.0	3.8	0.7	0.53	615	32.6	76
41	A	1.4	88.9	3.0	2.4	3.6	1.4	0.50	618	32.3	75
42	A	1.4	88.4	3.5	2.8	3.6	1.0	0.55	612	32.8	78
43	A	2.3	87.1	2.5	4.2	5.1	0.7	0.27	608	35.6	121
44	A	2.3	86.9	2.3	5.0	5.2	0.6	0.23	605	36.0	109
45	A	1.4	87.6	2.3	4.2	3.8	1.9	0.29	609	32.8	102
46	A	2.3	87.6	2.2	4.1	5.2	0.6	0.24	608	33.6	82
47	A	1.4	88.2	2.4	3.6	3.6	1.6	0.33	619	32.4	88
48	A	1.4	87.6	2.8	3.8	3.8	1.5	0.37	621	32.8	96
49	A	1.4	87.9	2.9	3.9	3.9	1.3	0.37	617	32.6	92
50	A	1.4	84.8	<u>0.3</u>	2.8	3.4	0.5	0.05	601	28.9	<u>62</u>
51	O	1.4	84.6	<u>0.2</u>	2.9	3.2	0.8	0.03	620	29.7	<u>64</u>
52	O	1.4	88.9	<u>4.7</u>	<u>0.8</u>	3.7	0.3	<u>1.04</u>	615	30.1	<u>65</u>
53	P	1.2	87.8	2.7	4.1	3.8	0.7	0.34	618	32.8	101
54	P	1.2	85.7	2.8	4.5	3.7	0.8	0.34	623	32.6	104
55	P	1.2	86.2	<u>0.4</u>	3.2	6.2	0.1	0.04	562	31.6	90
56	P	1.2	85.2	<u>0.3</u>	2.1	2.8	0.5	0.06	603	31.2	<u>62</u>
57	P	1.2	86.1	3.5	<u>0.6</u>	7.6	0.5	0.43	621	27.8	89
58	P	1.2	85.1	<u>8.1</u>	1.2	3.2	1.5	<u>1.84</u>	645	26.4	<u>65</u>
59	Q	1.6	87.8	2.1	4.1	4.4	0.6	<u>0.25</u>	620	32.8	100
60	Q	1.6	86.2	4.8	<u>0.2</u>	7.2	0.2	<u>0.65</u>	640	26.9	<u>69</u>

No.	TS × EL (MPa · %)	$\frac{\Delta T_1}{\Delta 20^\circ \text{C.}}$		$\frac{\Delta T_2}{\Delta 20^\circ \text{C.}}$		Surface	
		ΔTS	ΔEL	ΔTS	ΔEL	appearance	Remarks
31	22301	2.3	0.03	—	—	○	Invention example
32	22606	—	—	—	—	○	Invention example
33	20995	—	—	2.6	0.13	○	Invention example
34	20992	—	—	—	—	○	Invention example

TABLE 6-continued

35	19217	—	—	—	—	○	Comparative example
36	20850	—	—	—	—	○	Invention example
37	20467	—	—	—	—	Δ	Invention example
38	19716	—	—	—	—	○	Invention example
39	19796	—	—	—	—	○	Invention example
40	20049	—	—	—	—	○	Invention example
41	19961	—	—	—	—	○	Invention example
42	20074	—	—	—	—	○	Invention example
43	21645	—	—	—	—	○	Invention example
44	21780	—	—	—	—	Δ	Invention example
45	19975	—	—	—	—	x	Comparative example
46	20429	—	—	—	—	x	Comparative example
47	20056	—	—	—	—	x	Comparative example
48	20369	—	—	—	—	x	Comparative example
49	20114	—	—	—	—	x	Comparative example
50	<u>17369</u>	—	—	—	—	x	Comparative example
51	<u>18414</u>	—	—	—	—	x	Comparative example
52	<u>18512</u>	—	—	—	—	x	Comparative example
53	20270	1.3	0.05	—	—	○	Invention example
54	20310	—	—	—	—	○	Invention example
55	<u>17759</u>	—	—	—	—	x	Comparative example
56	<u>18814</u>	—	—	—	—	x	Comparative example
57	<u>17264</u>	—	—	—	—	x	Comparative example
58	<u>17028</u>	—	—	—	—	x	Comparative example
59	20336	—	—	—	—	Δ	Invention example
60	<u>17216</u>	—	—	—	—	x	Comparative example

Underlined portion: out of the scope of the present invention

F: ferrite, M: martensite, BF: bainitic ferrite, P: pearlite, RA: retained austenite

M/(BF + P): Area ratio of M/(Area ratio of BF + Area ratio of P)

TABLE 7

No.	Steel type	Sheet thickness (mm)	Area ratio of F (%)	Area ratio of M (%)	Area ratio of BF (%)	Area ratio of P (%)	Volume ratio of RA (%)	M/(BF + P)	TS (MPa)	EL (%)	λ (%)
61	Q	1.6	80.1	<u>0.6</u>	6.4	<u>10.3</u>	0.1	0.04	<u>538</u>	30.1	85
62	Q	1.6	84.1	<u>0.5</u>	4.5	<u>10.4</u>	0.3	0.03	592	31.2	85
63	Q	1.6	79.1	<u>6.3</u>	8.4	1.6	3.8	<u>0.63</u>	654	31.2	<u>50</u>
64	Q	1.6	84.2	<u>0.3</u>	4.4	<u>10.5</u>	0.2	0.02	595	31.6	87
65	Q	1.6	79.1	<u>6.5</u>	8.4	1.4	4.1	<u>0.66</u>	650	31.2	<u>55</u>
66	R	2.0	87.8	1.6	3.6	5.2	0.8	0.18	615	34.0	112
67	R	2.0	87.6	1.7	3.7	5.0	1.2	0.20	617	33.8	108
68	R	2.0	87.5	1.8	3.8	5.1	1.3	0.20	620	33.2	102
69	S	1.8	87.6	2.0	3.2	5.0	1.0	0.24	626	33.1	108
70	T	1.0	86.4	3.8	4.3	3.2	1.9	0.51	631	32.4	95
71	U	1.6	87.2	2.4	3.6	4.8	1.4	0.29	628	32.9	102
72	U	1.6	87.3	2.5	3.6	4.8	1.2	0.30	631	32.6	100
73	U	1.6	87.5	2.6	3.5	4.9	1.3	0.31	635	32.2	99
74	V	2.3	86.8	1.6	4.0	6.2	0.6	0.16	613	35.1	121
75	W	0.8	85.2	4.2	5.2	2.8	2.3	0.53	640	32.4	92
76	X	1.4	87.4	2.1	3.5	4.9	1.1	0.25	625	32.9	99
77	X	1.4	87.2	2.2	3.6	5.0	1.2	0.26	627	32.6	100
78	X	1.4	87.0	2.4	3.7	5.2	1.3	0.27	630	32.4	95
79	Y	1.4	81.4	<u>14.3</u>	<u>0.6</u>	<u>0.2</u>	2.2	<u>17.88</u>	596	31.6	60
80	Y	1.4	83.1	<u>12.8</u>	<u>0.7</u>	<u>0.3</u>	2.5	<u>12.80</u>	652	29.1	<u>45</u>
81	Y	1.4	85.2	<u>10.7</u>	<u>0.8</u>	<u>0.5</u>	2.6	<u>8.23</u>	698	26.4	<u>38</u>
82	Z	1.4	84.4	<u>12.1</u>	<u>0.4</u>	<u>0.4</u>	0.7	<u>15.13</u>	645	29.0	<u>41</u>
83	Z	1.4	86.4	<u>10.3</u>	<u>0.6</u>	<u>0.6</u>	0.9	<u>8.58</u>	621	29.8	<u>50</u>
84	Z	1.4	87.6	<u>8.9</u>	<u>0.8</u>	<u>0.3</u>	1.2	<u>8.09</u>	596	30.1	<u>57</u>
85	AA	1.2	88.2	<u>6.2</u>	<u>0.8</u>	<u>0.7</u>	2.6	<u>4.13</u>	609	30.5	62
86	AA	1.2	85.4	<u>8.2</u>	<u>0.8</u>	<u>0.6</u>	3.4	<u>5.86</u>	641	29.4	<u>48</u>
87	AA	1.2	82.1	<u>10.4</u>	<u>0.7</u>	<u>0.6</u>	3.8	<u>8.00</u>	684	27.9	<u>40</u>
88	A	2.3	87.8	2.0	3.2	5.6	1.2	0.23	610	34.8	120
89	A	2.3	87.9	2.2	3.0	5.2	1.2	0.27	606	35.0	115
90	A	2.3	87.1	1.9	3.6	5.9	1.2	0.20	603	34.9	114
91	A	2.6	86.9	3.4	3.5	4.2	1.7	0.44	619	36.1	118
92	A	3.2	87.1	3.2	3.1	4.5	1.9	0.42	612	36.8	123

	TS × EL	$\frac{\Delta T_1}{\Delta 20^{\circ} \text{C.}}$		$\frac{\Delta T_2}{\Delta 20^{\circ} \text{C.}}$		Surface appearance	Remarks
		ΔTS	ΔEL	ΔTS	ΔEL		
No.	(MPa · %)						
61	<u>16194</u>	—	—	—	—	x	Comparative example
62	<u>18470</u>	—	—	—	—	x	Comparative example
63	20405	—	—	—	—	x	Comparative example

TABLE 7-continued

64	<u>18802</u>	—	—	—	—	x	Comparative example
65	<u>20280</u>	—	—	—	—	x	Comparative example
66	<u>20910</u>	1.4	0.22	—	—	Δ	Invention example
67	<u>20855</u>	—	—	—	—	o	Invention example
68	<u>20584</u>	—	—	—	—	o	Invention example
69	<u>20721</u>	—	—	—	—	o	Invention example
70	<u>20444</u>	—	—	—	—	o	Invention example
71	<u>20661</u>	2.3	0.23	—	—	o	Invention example
72	<u>20571</u>	—	—	—	—	o	Invention example
73	<u>20447</u>	—	—	—	—	o	Invention example
74	<u>21516</u>	—	—	—	—	o	Invention example
75	<u>20736</u>	—	—	—	—	o	Invention example
76	<u>20563</u>	1.6	0.16	—	—	o	Invention example
77	<u>20440</u>	—	—	—	—	o	Invention example
78	<u>20412</u>	—	—	—	—	o	Invention example
79	<u>18834</u>	17.3	0.86	—	—	x	Comparative example
80	<u>18973</u>	—	—	—	—	x	Comparative example
81	<u>18427</u>	—	—	—	—	x	Comparative example
82	<u>18705</u>	—	—	14.0	0.31	x	Comparative example
83	<u>18506</u>	—	—	—	—	x	Comparative example
84	<u>17940</u>	—	—	—	—	x	Comparative example
85	<u>18575</u>	15.0	0.52	—	—	x	Comparative example
86	<u>18845</u>	—	—	—	—	x	Comparative example
87	<u>19084</u>	—	—	—	—	x	Comparative example
88	<u>21228</u>	1.4	0.04	—	—	o	Invention example
89	<u>21210</u>	—	—	—	—	o	Invention example
90	<u>21045</u>	—	—	—	—	Δ	Invention example
91	<u>22346</u>	—	—	—	—	o	Invention example
92	<u>22522</u>	—	—	—	—	o	Invention example

Underlined portion: out of the scope of the present invention

F: ferrite, M: martensite, BF: bainitic ferrite, P: pearlite, RA: retained austenite

M/(BF + P): Area ratio of M/(Area ratio of BF + Area ratio of P)

Since every one of our galvanized steel sheets has TS of 540 MPa or more and λ of 70% or more to exhibit excellent hole expansion property and, furthermore, satisfies $TS \times EL \geq 19,000$ MPa-% so that the balance between the strength and the ductility is high, it is clear that a high strength galvanized steel sheet having excellent formability is obtained by our methods of manufacturing high strength galvanized steel sheets. Moreover, the values of ΔTS and ΔEL are small and, therefore, it is clear that a high strength galvanized steel sheet having excellent stability of mechanical properties is obtained. On the other hand, in the comparative examples, at least one of the ductility and the hole expansion property is poor, or the stability of mechanical properties is not favorable.

Meanwhile, it is clear that our high strength galvanized steel sheets do not include non-coating and has excellent surface appearance, whereas in the comparative example, non-coating occurs and the surface appearance is poor.

INDUSTRIAL APPLICABILITY

The high strength galvanized steel sheets have a tensile strength TS of 540 MPa or more, exhibit high ductility and high hole expansion property, and further have excellent stability of mechanical properties. In the case where the high strength galvanized steel sheets are applied to, for example, an automobile structural member, enhancement of fuel economy due to weight reduction of a car body can be facilitated. Therefore, an industrial utility value is very large.

The invention claimed is:

1. A method of manufacturing a high strength galvanized steel sheet having excellent stability of mechanical properties, formability, and coating appearance, comprising:

applying a first heating step to a steel sheet containing C: 0.04% or more and 0.13% or less, Si: 0.7% or more and 2.3% or less, Mn: 0.8% or more and 2.0% or less, P: 0.1% or less, S: 0.01% or less, Al: 0.1% or less, N:

0.008% or less, and the remainder composed of Fe and incidental impurities, on a percent by mass basis, in which, in a former part, heating is performed in an atmosphere containing O_2 : 0.1 to 20 percent by volume and H_2O : 1 to 50 percent by volume at a temperature of 400° C. to 750° C. and, in a latter part, heating is performed in an atmosphere containing O_2 : 0.01 to less than 0.1 percent by volume and H_2O : 1 to 20 percent by volume at a temperature of 600° C. to 850° C.;

applying a second heating step to the resultant steel sheet, in which holding is performed in an atmosphere containing H_2 : 1 to 50 percent by volume and having a dew point of 0° C. or lower at a temperature of 750° C. to 900° C. for 15 to 600 s, cooling to a temperature of 450° C. to 550° C. is performed, and holding is performed at a temperature of 450° C. to 550° C. for 10 to 200 s; and applying a galvanization treatment, wherein the galvanized steel sheet includes 75% or more of ferrite phase, 1.0% or more of bainitic ferrite phase, and 1.0% or more and 10.0% or less of pearlite phase, on an area ratio basis, the area ratio of martensite phase is 1.0% or more and less than 5.0%, and the area ratio of the martensite phase/(area ratio of bainitic ferrite phase + area ratio of pearlite phase) < 0.6 is satisfied.

2. The method according to claim 1, wherein the steel sheet further contains at least one type of element selected from Cr: 1.0% or less, V: 0.5% or less, Mo: 0.5% or less, Ni: 1.0% or less, and Cu: 1.0% or less on a percent by mass basis.

3. The method according to claim 1, wherein the steel sheet further contains at least one type of element selected from Ti: 0.1% or less, Nb: 0.1% or less, and B: 0.0050% or less on a percent by mass basis.

4. The method according to claim 1, wherein the steel sheet further contains at least one type of element selected from Ca: 0.005% or less and REM: 0.005% or less on a percent by mass basis.

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5. The method according to claim 1, wherein the former part of the first heating step is performed with a direct fired furnace or a non-oxidizing furnace under the condition of an air ratio of 1 or more and 1.3 or less and the latter part of the first heating step is performed with a direct fired furnace or a non-oxidizing furnace under the condition of an air ratio of 0.6 or more and less than 1.

6. The method according to claim 1, wherein, after the galvanization treatment is applied, an alloying treatment of zinc coating is performed at a temperature of 500° C. to 600° C. under conditions satisfying Formula (1):

$$0.45 \leq \exp[200/(400-T)] \times \ln(t) \leq 1.0 \quad (1)$$

where

T: average holding temperature (° C.) at a temperature range of 500° C. to 600° C.,

t: holding time (s) at a temperature of 500° C. to 600° C., and exp(X) and ln(X) represent an exponential function and natural logarithm, respectively, of X.

7. The method according to claim 2, wherein the steel sheet further contains at least one type of element selected from Ti: 0.1% or less, Nb: 0.1% or less, and B: 0.0050% or less on a percent by mass basis.

8. The method according to claim 2, wherein the steel sheet further contains at least one type of element selected from Ca: 0.005% or less and REM: 0.005% or less on a percent by mass basis.

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9. The method according to claim 3, wherein the steel sheet further contains at least one type of element selected from Ca: 0.005% or less and REM: 0.005% or less on a percent by mass basis.

10. The method according to claim 2, wherein the former part of the first heating step is performed with a direct fired furnace or a non-oxidizing furnace under the condition of an air ratio of 1 or more and 1.3 or less and the latter part of the first heating step is performed with a direct fired furnace or a non-oxidizing furnace under the condition of an air ratio of 0.6 or more and less than 1.

11. The method according to claim 3, wherein the former part of the first heating step is performed with a direct fired furnace or a non-oxidizing furnace under the condition of an air ratio of 1 or more and 1.3 or less and the latter part of the first heating step is performed with a direct fired furnace or a non-oxidizing furnace under the condition of an air ratio of 0.6 or more and less than 1.

12. The method according to claim 4, wherein the former part of the first heating step is performed with a direct fired furnace or a non-oxidizing furnace under the condition of an air ratio of 1 or more and 1.3 or less and the latter part of the first heating step is performed with a direct fired furnace or a non-oxidizing furnace under the condition of an air ratio of 0.6 or more and less than 1.

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